

Date: Tuesday, 12/20/2005 9:02:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW KIT (13"X24")	
Job Number	: 25291		Part Number	: K10006	
Estimate Number	: 11540		Drawing Number	: D2672 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/20/2005 S.O. No. : N/A		Drawing Revision	: B1	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : MACHINED PARTS		Due Date	: 5/1/2006 Qty: 10 Um: Each	
Previous Run	: N/A				
Written By	: SEE COMMENT BELOW				
Checked & Approved By	: SEE COMMENT BELOW				
Comment	: Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  Comment: DOCUMENT CONTROL Photocopy bluefile: K10006 D206-559-023 D350-578-021 and create labels per PPP K10006 CHG004(Bag Bluefiles separately)
2.0	MUHMWB10	UHMW 1" Black  Comment: Qty.: 2.3427 sf(s)/Unit Total : 23.4266 sf(s) blank: 13.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2 Material: Black UHMW 1" (MUHMWB10) Batch: M15926 M17227 SD 06.01.16
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  Comment: HAAS CNC VERTICAL MACHINING #1 Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672/Identify as D2672

3-Deburr

JL/SD 06.01.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:02:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 25291

Part Number: K10006

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL / SN B6-0116

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/01/16

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0 D2182B050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B23172

8.0 D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B24872 71mcx 29mcx 828223

2 D2672(ref only) Bearpaw B25291

9.0 D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

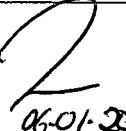
6 D2438 Clamp B23818 43mcx

B25015 X171



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-20	3	* 357 dims 1.357 from 1.357 * 310 cm one side only. Parts not perfectly centered/square.	 AS/FLD	part acceptable. See Also F.A.I. Sheet.	SD 06-01-20	 06-01-20	 AS/FLD	 06-01-20

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:02:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 25291

Part Number: K10006

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B25372

11.0 D2732050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B24182

12.0 AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085

13.0 AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M10432

14.0 AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M18431

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:02:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 25291

Part Number: K10006

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
12	MS21042L4	Nut (or -4)	M17997

Loc/1/24 (10)

16.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Loc/1/20 10

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10006

Location: _____

Rev 0

Loc/1/30 (10)

18.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Set 06/01/31

(10)

(10)

06/01/31

(10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bearpaw	Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SA</u>	Audited by: <u>SC</u>	Prototype Approval: N/A
Date: 06.01.16	Date: 06.01.16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	

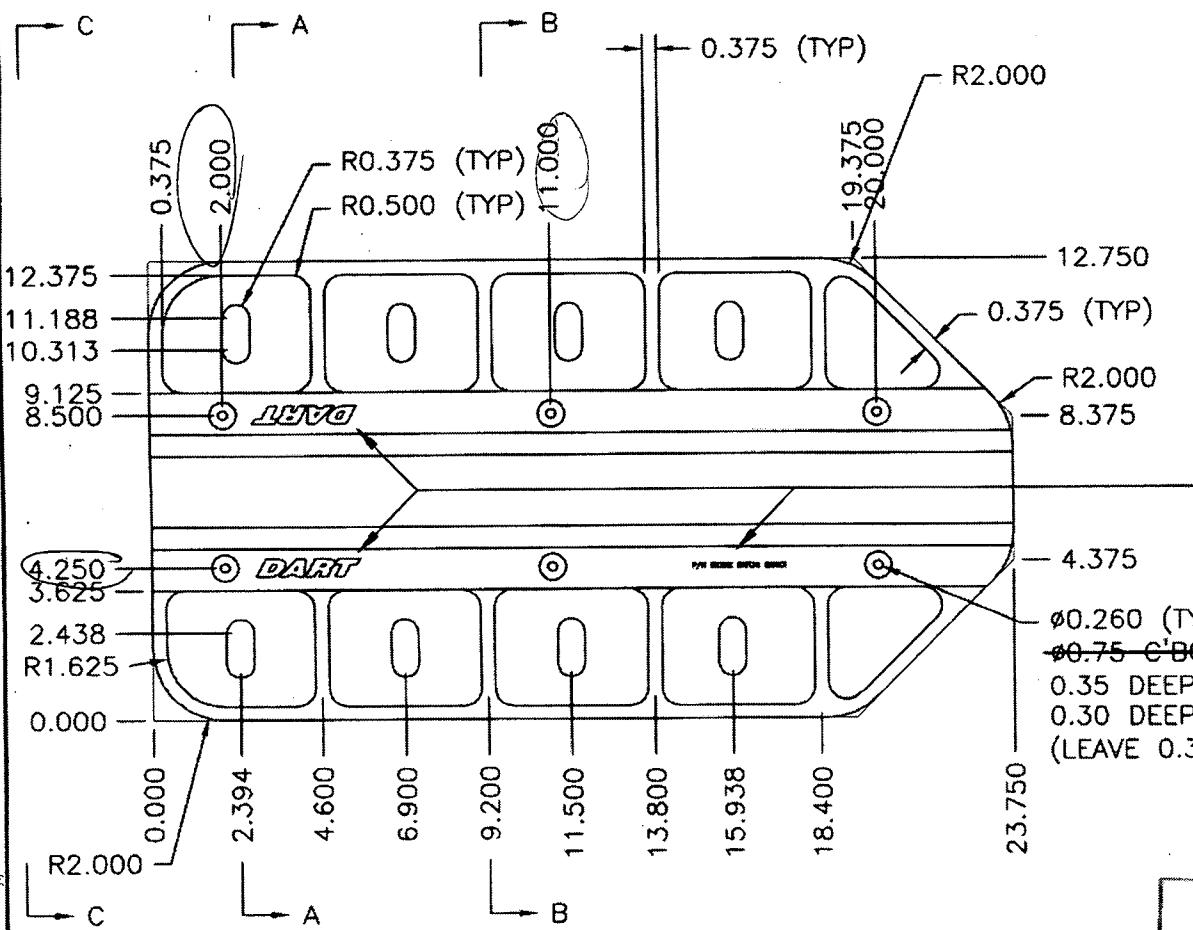
DART

DESIGN **KE** DRAWN BY **KE** DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. B

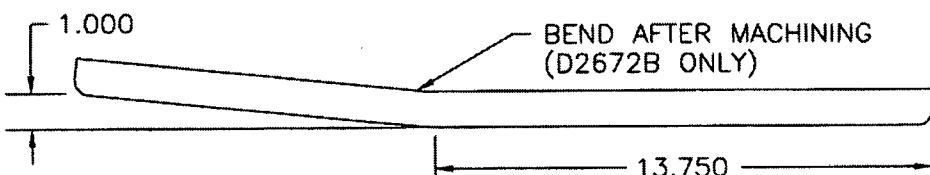
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2672	SHEET 1 OF 2
DATE	SCALE		
98.05.19		NEW ISSUE	
A	97.04.08	BEARPAW	
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	
B1	10.10.22	$\phi 0.43$ C'BORE 0.35 DEEP FROM TOP (MIN.) 0.30 DEEP FROM BOTTOM (LEAVE 0.300 MIN.)	

RELEASED98.06.17 **KE**

EFFECTIVE	DEOS
9/14/93	



BEND AFTER MACHINING
(D2672B ONLY)



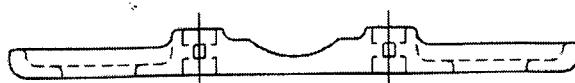
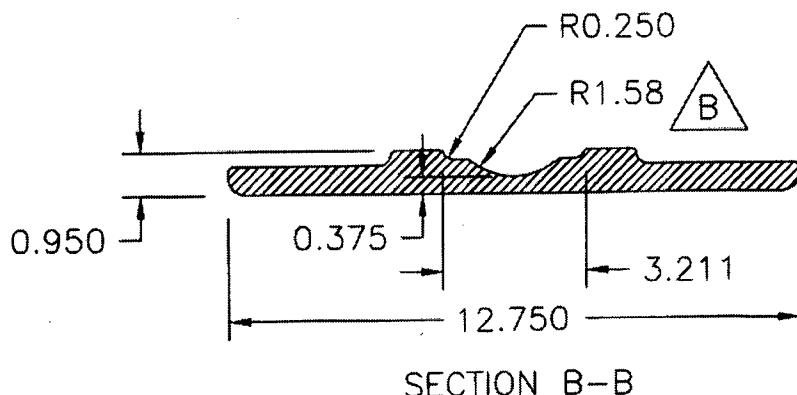
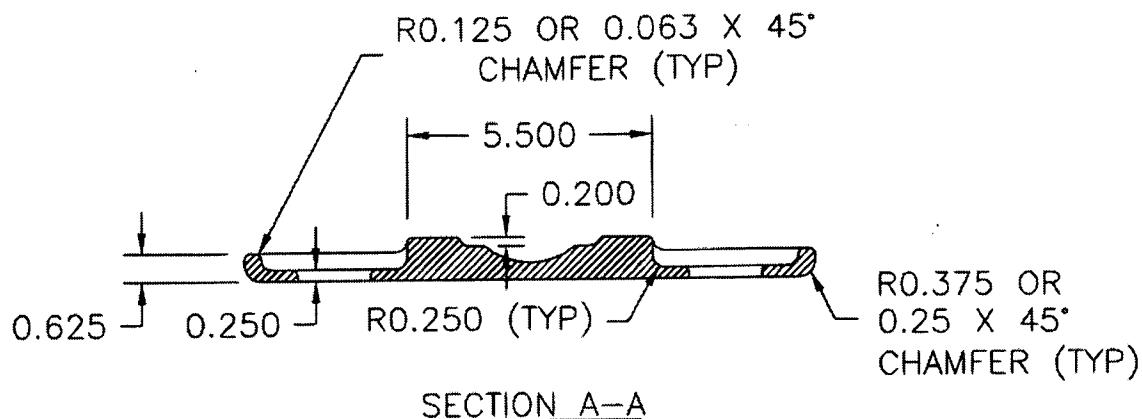
D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DART

COPY ISSUED

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>AS</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

RELEASED
09.06.17 KESECTION C-C